

Work Order ID 75593

75593

Wednesday, October 26, 2011 10:44:02 AM

Ship Nov 10th Page 1

Item ID: D412-742-013 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Float Skidtube Installation
 Start Date: 10/26/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 11/4/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: mw Date: 11-10-24 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D412-742	D

100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D412-742-013		CH0006						

CH0006
 046007

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

B75589

W/O: 75593

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11.12.09	100	Acceptable to assemble skid tube with D4095-xxx WEARPLATES PER D3371 Rev. I, which are equivalent to D3564-xxx WEARPLATES, HOWEVER THEY HAVE NO GASKETS ↳ DSI 9517 Rev. B	<i>[Signature]</i>	11.12.09		<i>[Signature]</i> 11.12.09	

 Part No: D412-742-013 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D412-742-013

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Float Skidtube Installation

Start Date: 10/26/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/4/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-742-013 Location: _____								
140		0.00							
140	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

★ SEE W/D
CHG

11/12/50
ME
11-12-05

Dart Aerospace Ltd

W/O: 15593		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11.11.21	100	RE-PRINT LABELS TO SAY CHG 007	M.C.B	11.12.2	1	CP 11.11.21 P51642	6 m12log

Part No: D412-742-013 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 75593

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 10/26/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev: A05.10.13New Issue KJ/JLM

IPP Rev:B 06-06-08 As per DSI9336 JLM IPP RevC 07-12-03 ECN 1072 DD
verified by:JLM

IPP Rev:D 08-09-08 ecn 08-510 DD verified by:EC

IPP Rev:E 09-01-23 as per DSI9441 DD verified by:EC IPP RevF: add AN4C7A DD 10.01.13
verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4C7A Bolt		Purchased	No			110	Each	331.0000	4	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST356		331							
				109147		331							
D412-742-043 Replacement Float Skidtube		Manufactured	No			110	Each	0.0000	1	1			
D2571 Saddle, Fwd Out 205		Manufactured	No			110	Each	7.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST433		7							
				72969		7							
D2572 Saddle, Fwd In 205		Manufactured	No			110	Each	4.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST433		4							
				71107		2							
				72968		2							
D2573 Saddle, Aft Out 205		Manufactured	No			110	Each	3.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST434		3							
				72936		3							

Handwritten notes and signatures: 11/10/12, 11/10/13, 11/10/14

Handwritten notes and signatures: 11/10/13, 11/10/14

Handwritten notes and signatures: 11/10/14

Picklist Print

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Work Order ID: 75593

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 10/26/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

D2574
Saddle, Aft In 205

Manufactured No

110 Each 3.0000

1 B73684 sl

Location

Loc Qty

Loc Code

ST434

3

72937

3

D2876
Saddle Spacer

Manufactured No

110 Each 31.0000

2 2

Location

Loc Qty

Loc Code

ST025

31

72136

31

D2877
Saddle Spacer

Manufactured No

110 Each 95.0000

2 2

Location

Loc Qty

Loc Code

ST025

95

72135

29

73309

66

D3403-1 Bushing Qty (B)

Manufactured No

110 Each 36.0000

2 B75672 sl

Location

Loc Qty

Loc Code

ST052

36

70696

29

71350

1

71842

6

D2747
Set Screw

Manufactured No

110 Each 142.0000

4 4

Location

Loc Qty

Loc Code

ST021

142

71163

42

73495

100

4

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Work Order ID: 75593

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 10/26/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

D3533-1
Set Screw
Manufactured No

110 Each 92.0000

2 2

Location

Loc Qty

Loc Code

ST065

92

73310

92

Purchased No

110 Each 442.0000

16 16

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

438

116704

15

118451

123

118983

100

119328

200

Purchased No

110 Each 93.0000

8 8

Location

Loc Qty

Loc Code

ST361

93

117163

36

117688

7

118451

50

Purchased No

110 Each 48.0000

8 8

Location

Loc Qty

Loc Code

ST341

48

118422

48

8 8

AN4C6A
Bolt

AN4C52A
BOLT

Qty (4)

+AN4C53A Qty (4)

MISSING

AN6C12A
BOLT

Picklist Print

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Work Order ID: 75593

Parent Item: D412-742-013

Start Date: 10/26/2011

Required Date: 11/4/2011

Parent Item Name: Float Skidtube Installation

Start Qty: 1.00

Required Qty: 1.00

D3672-3
Phenolic Washer

Manufactured No

110 Each 867.0000

32 32

Location	Loc Qty	Loc Code
ST074	867	
64176	180	
72230	187	
73487	500	

AN960C416L
WASHER
D3672-9
Phenolic Washer

Purchased No

110 Each 0.0000

32 32

Manufactured No

110 Each 264.0000

8 8

Location	Loc Qty	Loc Code
ST074	264	
35523	264	

NAS1149C0632R
WASHER

Purchased No

110 Each 120.0000

8 8

Location	Loc Qty	Loc Code
ST297	120	
118006	120	

D3672-11
Phenolic Washer

(Qty 18)

Manufactured No

110 Each 163.0000

16 16

Location	Loc Qty	Loc Code
ST074	163	
58046	163	

MS21043-4
Nut

Purchased No

110 Each 1,319.0000

29 29

Location	Loc Qty	Loc Code
FG	40	
104603	40	
ST301	1279	
117793	279	
118686	500	
119309	500	

27

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Work Order ID: 75593

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 10/26/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

~~D3403-3~~
Bushing

Manufactured No

110 Each 37.0000

8 8

Location

Loc Qty

Loc Code

ST

5

69509

5

ST052

32

71852

32

~~D3405-041~~
Lug Assembly

Manufactured No

110 Each 16.0000

1 1

Location

Loc Qty

Loc Code

ST423

3

70980

3

ST474

13

62227

2

73338

11

~~D3405-043~~
Lug Assembly

Manufactured No

110 Each 10.0000

1 1

Location

Loc Qty

Loc Code

ST423

2

65703

2

ST478

8

73339

8

~~AN4C47A~~
Bolt

RMV.

Purchased No

110 Each 73.0000

4 4

Location

Loc Qty

Loc Code

ST361

73

117163

23

118451

50

~~D3407-041~~
Tow Ring

Manufactured No

110 Each 4.0000

1 11/2/2011

Location

Loc Qty

Loc Code

ST463

4

73340

4

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Shop Packet Print

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Work Order ID: 75593

Parent Item: D412-742-013

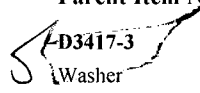
Parent Item Name: Float Skidtube Installation

Start Date: 10/26/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

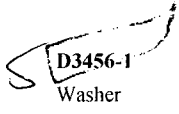


Manufactured No

110 Each 68.0000

2 2

Location	Loc Qty	Loc Code
FG	9	
33519	9	
ST053	59	
51648	12	
53182	23	
66847	24	

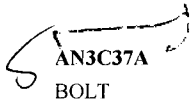


Manufactured No

110 Each 118.0000

1 B71033

Location	Loc Qty	Loc Code
FG	7	
25701	7	
ST054	111	
66848	3	
71165	8	
73493	100	



Purchased No

110 Each 137.0000

1 1

Location	Loc Qty	Loc Code
ST354	137	
116874	11	
117010	2	
118518	49	
118709	50	
119324	25	



Purchased No

110 Each 77.0000

1 11/20/28

Location	Loc Qty	Loc Code
ST354	77	
112454	27	
114442	50	

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Work Order ID: 75593

Parent Item: D412-742-013


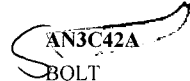
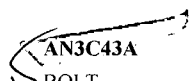
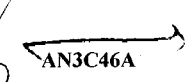
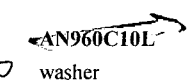
Parent Item Name: Float Skidtube Installation

Start Date: 10/26/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

	AN3C41A	Purchased	No		110	Each	134.0000	1	1
	BOLT								
				<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>		
				FG	4				
				103324	4				
				ST354	130				
				119035	80				
				119324	50				
	AN3C42A	Purchased	No		110	Each	43.0000	1	1
	BOLT								
				<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>		
				ST354	43				
				106176	1				
				117763	20				
				118131	20				
				118451	2				
	AN3C43A	Purchased	No		110	Each	53.0000	4	4
	BOLT								
				<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>		
				ST354	53				
				114455	20				
				117688	8				
				118387	25				
	AN3C46A	Purchased	No		110	Each	67.0000	5	5
	BOLT								
				<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>		
				ST355	67				
				118757	17				
				118758	50				
	AN960C10L	Purchased	No		110	Each	0.0000	26	26
	washer								
				<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>		
				ST355	67				
				118757	17				
				118758	50				

Picklist Print

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Work Order ID: 75593

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 10/26/2011

Required Date: 11/4/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-3

Nut

Purchased

No

110

Each

898.0000

13

13

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

826

118077

1

118614

477

118686

348

13

AWL
+ 1 A04C53A 1118562
11/11/30

5.2 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List

Item	Qty -013	Qty -043	Part Number	Description
	X		D412-742-013	FLOAT SKIDTUBE INSTALLATION
	1	X	D412-742-043	FLOAT SKIDTUBE
		1	D3391-043	412 FLOAT SKIDTUBE
1		*24	*AN3C4A	*BOLT
3		*12	*AN3C6A	*BOLT
4		*8	*AN3C7A	*BOLT
5		*44	*AN960C10L	*WASHER
21A		*1	*D3564-1	*WEARSHOE (REPLACES D3460-1)
21B		*1	*D3566-1	*GASKET
22A		*1	*D3564-3	*WEARSHOE (REPLACES D3460-3)
22B		*1	*D3566-1	*GASKET
23A		*1	*D3564-5	*WEARSHOE (REPLACES D2577-5)
23B		*1	*D3566-5	*GASKET
10		*1	*D3391-021	*412 FORWARD TUBE
11		**1	**D3401-041	**TOW CAP
12A		**10	**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB166)
12B		**2	**AELS-1032-130	**INSERT (REPLACES NAS1330S3KB166)
13		**10	**AN3C4A	**BOLT
14A		**4	**D3672-1	**WASHER (REPLACES NAS1515H3L)
14B		**10	**AN960C10L	**WASHER
24A		**1	**D3564-13	**WEARSHOE
24B		**1	**D3566-13	**GASKET
20		*1	*D3391-023	*412 MID TUBE
28		**20	**AELS-1032-130	**INSERT (REPLACES NAS1330S3KB116)
30		*1	*D3391-025	*412 AFT TUBE
25A		**1	*D3537-1	**WEARPAD
25B		**1	*D3553-1	**GASKET
26A		**1	*D3537-7	**WEARPAD
26B		**1	*D3553-3	**GASKET
31		**1	**D2646	**AFT CAP
32		**14	**AELS-1032-130	**INSERT
36		**12	**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB366)
37A		**6	**AN3C4A	**BOLT
37B		**4	**AN3C5A	**BOLT
38A		**2	**D3672-1	**WASHER (REPLACES NAS1515H3L)
38B		**10	**AN960C10L	**WASHER

(CONTINUED ON PAGE 19)

(CONTINUED FROM PAGE 18)

Item	Qty -013	Qty -043	Part Number	Description
40	1		D2571	SADDLE, FWD OUTSIDE
41	1		D2572	SADDLE, FWD INSIDE
42	1		D2573	SADDLE, AFT OUTSIDE
43	1		D2574	SADDLE, AFT INSIDE
44	2		D2876	SADDLE SPACER
45	2		D2877	SADDLE SPACER
46	16		D3403-1	BUSHING
47A	4		D2747	SET SCREW
47B	2		D3533-1	SET SCREW
48	16		AN4C6A	BOLT
49	8		AN4C52A	BOLT
50	8		AN6C12A	BOLT
51A	32		D3672-3	WASHER (REPLACES NAS1515H4L)
51B	32		AN960C416L	WASHER
52A	8		D3672-9	WASHER (REPLACES NAS1515H6L)
52B	8		AN960C616L	WASHER
53	16		D3672-11	WASHER (REPLACES NAS1515H7L)
54	24		MS21043-4	NUT
55	4		ANC47A	BOLT
60	8		D3403-3	BUSHING
61	1		D3405-041	GHW LUG
62	1		D3405-043	GHW LUG
63	4		AN4C46A	BOLT
64	4		MS21043-4	NUT
70	1		D3407-041	TOW RING
71	2		D3417-3	WASHER
72	1		MS21043-4	NUT
73	1		D3456-1	WASHER
91	1		AN3C37A	BOLT
92	1		AN3C40A	BOLT
93	1		AN3C41A	BOLT
94	1		AN3C42A	BOLT
95	4		AN3C43A	BOLT
97	5		AN3C46A	BOLT
99	26		AN960C10L	WASHER
100	13		MS21043-3	NUT

*DENOTES PART IS INCLUDED WITH D3391-043 ASSEMBLY ABOVE

**DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: D

Date: 07.10.04

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-742 REV. D AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-742 REV. 3.

REF. FAA STC: SR01583SE

REF. CANADIAN STC: SH05-37

REF. EASA STC: EASA.IM.R.S.01126

REFERENCE ONLY

INSTRUCTIONS:

- 1) FOR D412-742-011/-013 SKIDTUBES @ CHANGE 006 AND SUBSEQUENT, UPDATE THE PARTS LIST TO MODIFY THE BOLT USED TO ATTACH THE GHW LUG AS FOLLOWS:

5.1 D412-742-011 (PMA/OEM) Float Skidtube Installation Parts List

32.15 D412-742-011 (PMA/OEM) Float Skidtube Installation Parts List

ITEM	Qty -011	Qty -041	Qty -015	PART NUMBER	DESCRIPTION
	X			D412-742-011	FLOAT SKIDTUBE INSTALLATION
	1	X		D412-742-041	FLOAT SKIDTUBE
	1		X	D412-742-015	ELECTRIC STEP KIT

IS:

63	4			AN4C47A	BOLT
----	---	--	--	---------	------

WAS:

63	4			AN4C46A	BOLT
----	---	--	--	---------	------

5.2 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List

32.16 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List

ITEM	Qty -013	Qty 043	PART NUMBER	DESCRIPTION
	X		D412-742-013	FLOAT SKIDTUBE INSTALLATION
	1	X	D412-742-043	FLOAT SKIDTUBE

IS:

63	4			AN4C47A	BOLT
----	---	--	--	---------	------

WAS:

63	4			AN4C46A	BOLT
----	---	--	--	---------	------

A	NEW ISSUE	AJS	08.12.19
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9441	SHEET 1 OF 1
APPROVED	W	TITLE	SCALE
DE APPR.	W	BOLT CHANGE	NTS
DATE	08.12.19	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O: 75593		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
11.11.15		REMOVE: Qty (8) D3403-1 BUSHING (8 REMAINING) Qty (4) AN4C47A BOLT Qty (4) AN4CS2A BOLT (4 REMAINING) M118451 4x Qty (8) D3672-11 WASHER (8 REMAINING) B 58046 82				OP 11.11.15 DS1 042	S 11.11.16	
		ADD: Qty (8) D3403-5 BUSHING B/N 74761 Qty (4) AN4CS3A BOLT B/N 119558		11.11.1		OP 11.11.15 DS1 042	S 11.11.16	

REF DS1 9517 Rev 13

Part No: D412-742-013 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Chris Provencal

From: David Shepherd <dshepherd@dartaero.com>
Sent: Friday, November 18, 2011 3:21 PM
To: 'Chris Provencal'
Cc: 'Mike Petsche'; 'L Lacelle'
Subject: RE: Frankentribeams

I agree that these should be shipped as CHG 007.

David

From: Chris Provencal [<mailto:cprovencal@dartaero.com>]
Sent: November-18-11 12:17 PM
To: David Shepherd
Cc: Mike Petsche; 'L Lacelle'
Subject: Frankentribeams

David,

RE: D412-742-013

We were planning on sending two tri-beams at the old change number with the DSI wearplate kit installed. The customer wants all new wearplates. Additionally, one of the aft tubes was scrapped due to excessive machining marks on the ID, so it is replaced with a new-style tube.

This basically means we'd be shipping CHG 006 tubes, with CHG 007 wearplates, and one CHG 007 aft tube on one of the tubes. This isn't really covered by the DSI. I think that these should be shipped as CHG 007 (since from a customer standpoint, they are more functionally a CHG 007) with a deviation that the tubes have additional holes filled per the DSI. Is this acceptable?

-Chris

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries